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D350-591-213
Job Sheet 182113



Part No: D350-591-213

Job Qty: 4 ea

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/17/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV H IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLMIPP REV:D 14.12.17 ADD DSI9712-011 DD VERF:JLM IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D 10.03.17 incorporate seq 180 to 200 remove qc5 DD verified by:JLM IPP Rev:E 10.11.15 update qty on AN4-11A DD ver:EC IPP REV:F 16.03.16 IIN REV:H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Stores/Pkg-2	0.00	SEP 19 2018
270	Packaging	4 pcs	8/31/18	8/31/18	0.00	0.00	Packaging1-3	0.00	SEP 20 2018
280	QC	4 pcs	8/31/18	8/31/18	0.00	0.00	QC4	0.00	SEP 20 2018
290	Packaging	4 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3-1	0.00	SEP 20 2018
295	DC	4 pcs	8/31/18	8/31/18	0.00	0.00	DC	0.00	SEP 21 2018
300	QC21-FG	4 Ea	8/31/18	8/31/18	0.00	0.00	QC21	0.00	SEP 21 2018

Part Op 290 - Identify and pack for shipping as per PPP D350-591-213

Descriptions: 295 - Photocopy bluefile and type labels as per PPP D350-591-213 CHG005

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-35A	Bolt	8 Ea (2 ea)	90-Start up Operation	
AN4-15A	Bolt	16 Ea (4 ea)	90-Start up Operation	
AN5-36A	Bolt	8 Ea (2 ea)	90-Start up Operation	
D2230-3	Mounting Lug	8 Ea (2 ea)	90-Start up Operation	
D2618	Bushing	8 Ea (2 ea)	90-Start up Operation	
D2732-030	Rubber Cushion - 3"	16 Ea (4 ea)	90-Start up Operation	
D3235-1	Mounting Lug	8 Ea (2 ea)	90-Start up Operation	
D3338-1	Mounting Lug	4 Ea (1 ea)	90-Start up Operation	
MS21042L3	Nut	8 Ea (2 ea)	90-Start up Operation	
MS21042L4	Nut	24 Ea (6 ea)	90-Start up Operation	
MS21042L5	Nut	8 Ea (2 ea)	90-Start up Operation	
NAS1149D0363J	Washer	16 Ea (4 ea)	90-Start up Operation	
NAS1149D0463J	Washer	48 Ea (12 ea)	90-Start up Operation	
NAS1149D0563J	Washer	16 Ea (4 ea)	90-Start up Operation	
D3078-041	Step Assembly, Hi Short LH	4 Ea (1 ea)	270-Packaging	

Instructions: TC STC SH92-6 Issue 11, FAA STC SH967NE 04/12/21, BRAZIL 1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-35A	8	403	0
	AN4-15A	16	685	0
	AN5-36A	8	346	0
	D2230-3	8	219	0
	D2618	8	195	0
	D2732-030	16	300	0
	D3235-1	8	44	0
	D3338-1	4	66	0
	MS21042L3	8	3,288	0
	MS21042L4	24	4,086	0
	MS21042L5	8	864	0
	NAS1149D0363J	16	2,245	0
	NAS1149D0463J	48	7,192	0
	NAS1149D0563J	16	1,636	0
270-Packaging	D3078-041	4	5	0

Part Specifications

Specifications could not be found.



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
005545	S111633	AN3-35A	Bolt	S047337	ST348	8
005545	S111632	AN4-15A	Bolt	s083012	ST343	16
005545	S111631	AN5-36A	Bolt	s083019	ST336	8
005545	S111630	D2230-3	Mounting Lug	s106786	ST521	8
005545	S111629	D2618	Bushing	s089996	ST008	8
005545	S111628	D2732-030	Rubber Cushion - 3"	s108181	ST410	16
005545	S111627	D3235-1	Mounting Lug	s11532	ST522	8
005545	F160521	D3338-1	Mounting Lug		ST527	1
005545	S080379	D3338-1	Mounting Lug	S080378	ST527	2
005545	S111614	D3338-1	Mounting Lug	S094532	ST527	1
005545	S111608	MS21042L3	Nut	s089340	ST303	8
005545	S111606	MS21042L4	Nut	s094597	ST303	24
005545	S111605	MS21042L5	Nut	s083541	ST303	8
005545	S111604	NAS1149D0363J	Washer	s068661	ST263	16
005545	S111602	NAS1149D0463J	Washer	s089299	ST263	48
005545	S111600	NAS1149D0563J	Washer	s093773	ST263	16

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

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D3078-041 5107967

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
	X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
		X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
			X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
				X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
					X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3
REF TCCA STC: SH92-6
REF FAA STC: SH967NE

1.0 Purpose

It has come to DART's attention that it may be difficult to fasten the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Installations to the forward crosstube due to variations between crosstubes. For this reason, DART is adding the D3338-1 Mounting Lug to the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Kits at CHG 004 and later.

For D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Kits at CHG 003 and earlier, DSI 9712-011 Mounting Lug Kit can be procured from DART. The kit contains all parts to upgrade a single step kit.

2.0 Installation

- 2.1 It is acceptable to install the D3338-1 Mounting Lug in lieu of the D2230-1 Mounting Lug as required to reduce the gap between step and the forward crosstube in accordance with the figures of this service instruction.
- 2.2 The height to set up the D350-591-133 Maintenance Step has been revised from 7.0in to 6.0in $\pm$ 1.0in to provide more flexibility. See sheet 2 of this service instruction.
- 2.3 In all other respects, install the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Steps in accordance with Section 3.1 of Installation Instructions D350-591 or Section 32.1 of Instructions for Continued Airworthiness ICA-D350-591.

3.0 Parts List Change

The following additional part is provided with D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Steps at CHG 004:

Qty -133	Qty -213	Qty -214	Part Number	Description
X			D350-591-133	Heli-Access-Step™, Aft Maintenance Step
	X		D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
		X	D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
1	1	1	D3338-1	MOUNTING LUG (ADD)

4.0 DSI 9712-011 Mounting Lug Kit Parts List

For existing D350-591-133 Aft Maintenance Steps and D350-591-213/-214 Heli-Access-Steps at CHG 003 or earlier, one DSI 9712-011 kit upgrades one step installation:

Qty -011	Part Number	Description
X	DSI 9712-011	Mounting Lug Kit
1	D3338-1	MOUNTING LUG

5.0 Weight and Balance

There is a negligible weight change associated with this modification.

REFERENCE ONLY

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. Shepherd
D. SHEPHERD (DE # 02)

DATE: 14.12.04
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	MB	14.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>1</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>1</u>		
CHECKED	<u>1</u>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9712	SHEET 1 OF 3
APPROVED	<u>1</u>	TITLE	SCALE
DE APPR.	<u>1</u>	INSTALLATION OPTION	NTS
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